

## Claims

[c1] 1. A tool holder assembly for a cutting tool having an end surface and a fluid passage, the tool holder assembly comprising:

    a tool holder including:

        a counterbore adapted to receive the cutting tool and having a bottom surface; and

        a conduit axially aligned with the counterbore;

    an locating member including:

        a body portion at least partially disposed in the conduit;

        a flange portion disposed in the counterbore adjacent to the body portion; and

        an internal fluid passage defined by the body and flange portions; and

    a spring configured to bias the locating member to engage the end surface to inhibit fluid leakage.

[c2] 2. The tool holder assembly of claim 1 wherein the spring is disposed between the flange portion and the bottom surface.

[c3] 3. The tool holder assembly of claim 1 wherein the spring is disposed between the flange portion and the conduit.

- [c4] 4. The tool holder assembly of claim 1 wherein the flange portion further comprises a chamfer disposed proximate the fluid passage and adapted to engage the end surface.
- [c5] 5. The tool holder assembly of claim 1 wherein the locating member further comprises a connection tube attached to the body portion and at least partially disposed in the conduit.
- [c6] 6. The tool holder assembly of claim 5 wherein the spring is disposed between the flange portion and the connection tube.
- [c7] 7. The tool holder assembly of claim 5 wherein the connection tube further comprises a first section at least partially disposed in the conduit and a second section at least partially disposed in the internal fluid passage.
- [c8] 8. The tool holder assembly of claim 5 wherein the flange portion has a larger diameter than the connection tube.
- [c9] 9. The tool holder assembly of claim 1 wherein the flange portion has a larger diameter than the body portion.
- [c10] 10. The tool holder assembly of claim 1 further compris-

ing a seal disposed between the flange portion and the end surface.

- [c11] 11. A tool holder assembly for a cutting tool having an end surface and a fluid passage, the tool holder assembly comprising:
  - a tool holder including:
    - a counterbore adapted to receive the cutting tool and having a bottom surface; and
    - a conduit axially aligned with the counterbore;
  - an locating member including:
    - a body portion at least partially disposed in the conduit;
    - a flange portion having a larger diameter than the body portion disposed in the counterbore adjacent to the body portion; and
    - an internal fluid passage defined by the body and flange portions;
    - a connection tube disposed proximate the body portion and the conduit; and
    - a spring configured to bias the locating member to engage the end surface to inhibit fluid leakage.
- [c12] 12. The tool holder assembly of claim 11 wherein the connection tube is integrally formed with the locating member.
- [c13] 13. The tool holder assembly of claim 11 wherein the

connection tube further comprises a first section and a second section disposed proximate the first section and having a smaller diameter than the first section.

- [c14] 14. The tool holder assembly of claim 13 wherein the second section is disposed at least partially in the internal fluid passage.
- [c15] 15. The tool holder assembly of claim 13 wherein the spring is configured to engage the flange portion and the first section.
- [c16] 16. The tool holder assembly of claim 11 wherein the spring is configured to engage the flange portion and the bottom surface.
- [c17] 17. The tool holder assembly of claim 11 wherein the spring is configured to engage the flange portion and the conduit.
- [c18] 18. A tool holder assembly for a cutting tool having an end surface and a fluid passage, the tool holder assembly comprising:
  - a tool holder including:
  - a counterbore adapted to receive the cutting tool and having a bottom surface; and
  - a conduit axially aligned with the counterbore and having a first inside diameter and a second inside diameter;

an locating member including:  
a body portion at least partially disposed in the conduit;  
a flange portion disposed in the counterbore adjacent to  
the body portion; and  
an internal fluid passage defined by the body and flange  
portions;  
a connection tube at least partially disposed in the con-  
duit; and  
a spring configured to bias the locating member to en-  
gage the end surface to inhibit fluid leakage.

- [c19] 19. The tool holder assembly of claim 18 wherein the first inside diameter is smaller than the second inside di-  
ameter.
- [c20] 20. The tool holder assembly of claim 19 further com-  
prising an engagement surface disposed proximate the first and second inside diameters wherein the spring is  
configured to engage the flange portion and the engage-  
ment surface.